Wo	rk	Or	der	ID	68	48	2
mi				2011		0.0	



Page 1

Thursday, April	14, 2011 10:	02:10 AM								** ** * ******************************	
Item ID:	D3296-3		-	Accept ,				s	etup Star	rt	
Revision ID:						#::: ##::: #:#:: ##			Sto		
Item Name:	Door Panel								510	Р	
Start Date:	4/14/2011	Start Qty: 12.00			Cust Item	ID:		•		*	
Required Date:	4/21/2011	Req'd Qty: 12.00			Customer	:				,	
Reference:											(255 0 501 1 101 1 111 1
Approvals:	Process Pla	n:	Date://-04/14/	Tooling:		Date:	_	P	tun Star		
	QC:	/ (Date:	SPC (Y/N):	<u> </u>	Date:			Sto	p	
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	ision Nbr		-							
D3296	Rev	A									
100				0,00					***************************************		
		FLOW WATER JET						BU	5-3_		
Waterjet		Memo		0.00	A					-	
FLOW CNC Waterje		1-Cut as per Deburr if ne		□Prog Rev:_	& □2-					(2
110		QC2- Inspect parts off m	achine FAI/FAIB	0.00							
								15/1-			3
QC		Memo		0.00					<u> </u>		
Quality Control											
	•										
120		QC8- Inspect parts - seco	nd check	0.00	ustat			412)		
QC		Memo		0.00	9 10 1			-10			-
Quality Control											

W/O:	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,		V	ORK ORDER CHANG	ES			
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					`		r roa wigi	
				•				
-								
							-	
Part No	# =	PAR #:	Fault Ca	tegory:	NCR: Yes	No DQA:	Date: _	
	·R	esolution:	Disposit	ion:	_ QA: N/C Cld	osed:	Date: _	***************************************
NCR:		V	VORK OR	DER NON-CONFORMA	NCE (NCR)		ŧ
	0750	Description of NC		Corrective Action Section		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
,		,						
				<u> </u>				
						•		

Work Order ID 68482

Page 2

Thursday, April 14, 2011 10:02:10 AM

Item ID:

-- D3296-3

Accept



Setup Start



Revision ID:

Item Name: **Start Date:**

Door Panel

4/14/2011

Start Qty: 12.00

Required Date: 4/21/2011 Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

130

Small Fab

Small Fab

Operation Description

Small Fab

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

140

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

150

Quality Control

QC3- Inspect Part Finish

Memo

Memo

0.00

=7 m/h 11/05/

W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		÷							
Part No	:	PAR #:	Fault Cat	egory:	_ NCR: Yes I	No DQ	A:	Date: _	
	R	esolution:	Dispositi	on:	_ QA: N/C Cld	sed:		Date: _	
NCR:		1	WORK ORE	DER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Section	on B Sign &	Verific		Approval	Approval
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Date Date	Secti	on C	Chief Eng	QC Inspector
				-					

Work Order ID 68482

Page 3

Thursday, April 14, 2011 10:02:10 AM

Item ID:

D3296-3

Accept



Setup Start

Stop



Revision ID:

Start Date:

Door Panel Item Name:

Required Date: 4/21/2011

4/14/2011

Start Qty: 12.00

Req'd Qty: 12.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:_____

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Set Up/

Date:

Stop

Sequence ID/ Work Center ID

160

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location: 186

Memo

Memo

Run Hours

0.00

0.00

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number

Stamp

170

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

W/O:			W	ORK ORDER CHANG	RES				
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		-							
Part No	•	PAR #:	Fault Cate	egory:	NCR: Ye	es No D	QA:	Date:	
	R	esolution:	Disposition	on:	_ QA: N/C	Closed: _		Date: _	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (N	CR)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sec Action Description Chief Eng	tion B Sig	n& _{Se}	ification ection C	Approval Chief Eng	Approval QC inspector

Picklist Print

Thursday, April 14, 2011 10:02:16 AM

Work Order ID: 68482

Parent Item:

D3296-3

Parent Item Name: Door Panel



Start Date: 4/14/2011

Required Date: 4/21/2011

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP C□05.10.14□Added step 14□KJ/EC

IPP Rev:E Now on Waterjet 06-11-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			110	sf	330.5700	0.6532	8.250947	•		· · · · · · · · · · · · · · · · · · ·
										48	311-5-3		

2024-T3 .063 sheet

Location	Loc Qty	Loc Code	
MAT022 .	330.57		
113867	1.19		
117018	41.38		
117392	288		1(739)



W/O:			· W	ORK ORDER CHANG	ES					1
DATE	STEP	PRO	OCEDURE CH	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		·	•							
				,						
							-			
Part No	:	PAR #:	Fault Cate	egory:	_ NC	R: Yes I	No DQA :		Date:	
	Re	esolution:	Disposition	on:	_ QA	: N/C Cld	sed:		Date:	-
NCR:		1	WORK ORD	ER NON-CONFORMA	NCE	(NCR)			
DATE	OTED	Description of NC		Corrective Action Section	on B		Verificat	ion	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector
	·									
	·									
			•	*			,			
				·			*			

DART AEROSPACE LTD	Work Order:	68482
Description: Door Panel	Part Number:	D3296-3
Inspection Dwg: D3296 Rev: A		Page 1 of 1

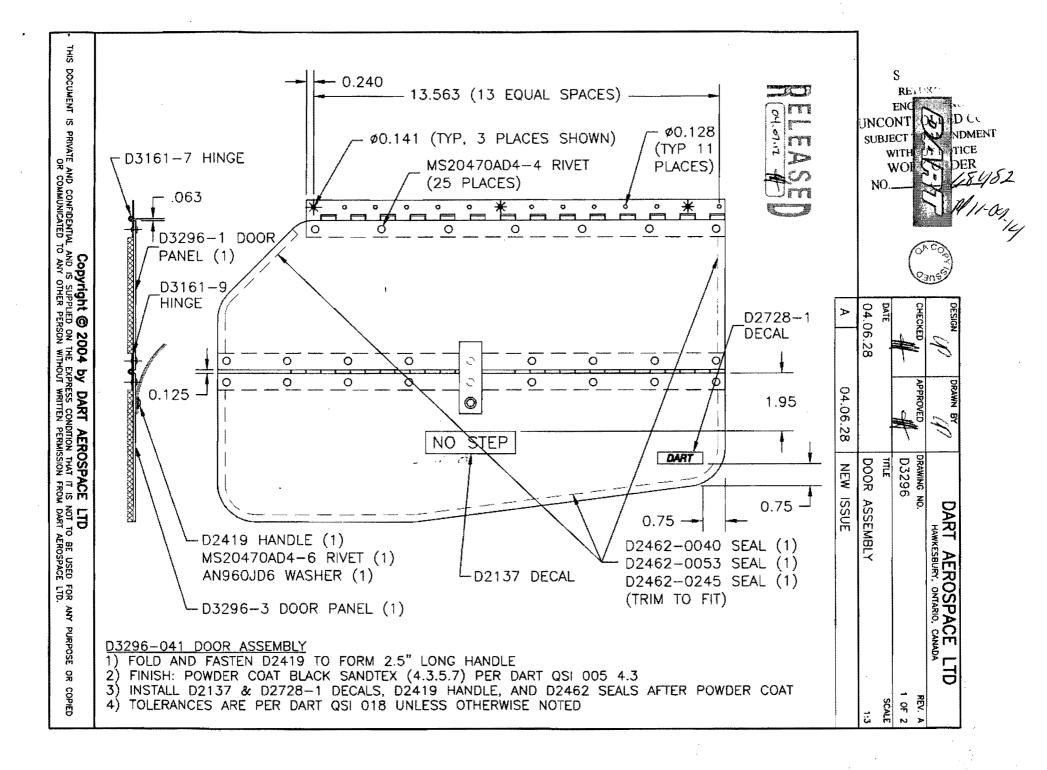
FIRST ARTICLE INSPECTION CHECKLIST

	X	First Art	icle	Prot	otype	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.03	+/-0.030	5.040	*		V 1802	
R0.060	+/-0.010	, ৫১০	*		R.G.	
Ø0.128	+0.005/-0.000	130	*		V	
17.00	+/-0.030	17.000	b		V BOI	
16.400	+/-0.005	16,400	×		V	
0.300	+/-0.010	- 301	×		V	
0.300	+/-0.010	, 301	2		V	
1.00	+/-0.030	.948)	*		٧	
0.063	+/-0.010	(පහ,	9		V	
					,	

	·		
Measured by: R	Audited by:	Prototype Approval:	N/A
Date: (1-5-3	Date: ((c) / 04	Date:	N/A

Rev	Date	Change		Revised by	Approv <i>e</i> d
Α	04.08.24	New Issue	P/O D3296-041	KJ/JLM o	- (11)

W/O:			W	ORK ORDER CHAN	GES							
DATE	STEP	PROCEDURE CHANGE			Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
									r roa wigi			
		PAR #:	Fault Category: NO			NCR: Yes No DQA: Date:						
		esolution:				QA: N/C Closed:						
NCR:		V	VORK ORD	ER NON-CONFORM	IANCE (N	CR)						
DATE	0	Description of NC		Corrective Action Section B			Verification		Approval	Approval		
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sig D	ın & ate	Section		Chief Eng	QC Inspector		
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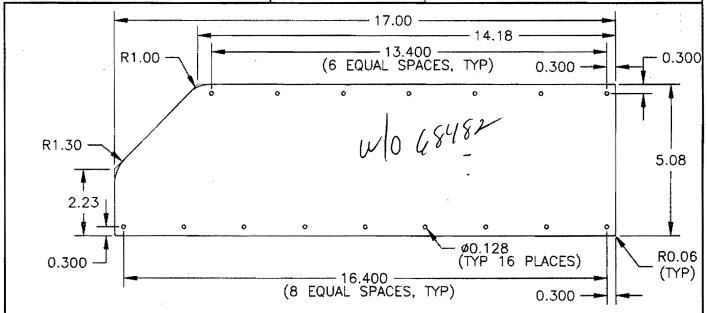


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W/O:			W	ORK ORDER CHANG	ES		<u></u>				
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
										r	
		÷									
Part No		PAR #:	Fault Cate	gory:	_ NCI	R: Yes	No DQ /	A:	Date:		
			Disposition: Q								
NCR:			WORK ORD	ER NON-CONFORMA	ANCE	(NCR)				
DATE	STEP	TEP Description of NC Section A	Corrective Action Section B		ion B	Sign &	Verific		Approval	Approval	
			Initial Chief Eng	Action Description Chief Eng		Date	Secti	on C	Chief Eng	QC Inspector	
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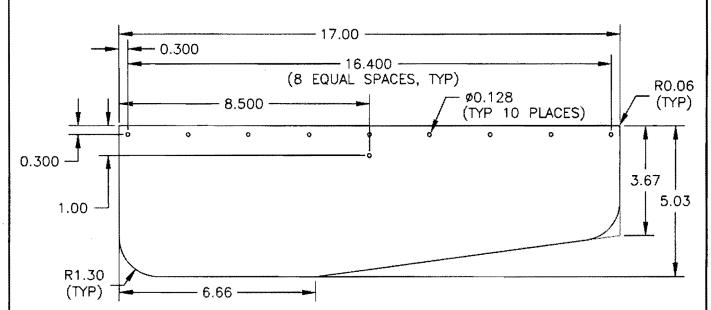




DESIGN ()	DRAWN BY	DART AEROSPA HAWKESBURY, ONTARK	
CHECKED	APPROVED	DRAWING NO.	REV. A
H	#	D3296	2 OF 2
DATE		TITLE	SCALE
04.06.28		DOOR ASSEMBLY	1:3



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF DART SPEC. M2024T3S.063)

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:			V	VORK ORDER CHANG	GES							
DATE	STEP	PROCEDURE CHANGE				Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
			•									
-												
Part No: PAR #:		PAR #:	Fault Category: NO			NCR: Yes No DQA: Date:						
Resolution:			Disposit	Disposition: QA			sed:	_ Date:				
NCR:		V	VORK OR	DER NON-CONFORM	ANCE (NCR)						
DATE	STEP	Description of NC	Corrective Action Section B				Verification		Approval	Approval		
	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	8	ign & Date	Section C		Chief Eng	QC Inspector		
25												
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